

Work Order ID 100598-2

April-24-13 9:48:31 AM

100598

Page 1

Item ID: D4543-3

Revision ID:

Item Name: Retainer, Outer, LH

Start Date: 4/24/13 Start Qty: 30.00

Required Date: 5/08/13 Req'd Qty: 30.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals: Process Plan: MLS

Date: 13-04-24 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4543

B

100

0.00

100

Waterjet

0.00

FLOW CNC Waterjet

6061 T6 032

Memo

1- Cut as per dwg

Prog rev: B

Dwg rev: B

2- Deburr

30 0

JM13-4-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

30 0

JM13-4-24

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Page 2

Item ID: D4543-3

Revision ID:

Item Name: Retainer, Outer, LH

Start Date: 4/24/13 Start Qty: 30.00

Required Date: 5/08/13 Req'd Qty: 30.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				30			
Quality Control									
130		0.00							
130									
Small Fab	Memo	0.00				30			FF
Small Fab	FORM ON BEAD ROLLER (DT9787)								13-04-25
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				30			Checked again
Quality Control									Helworks
									template

OK GP
13/4/28

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Item ID: D4543-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Outer, LH

Stop *NS2*

Start Date: 4/24/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/08/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

30 134.29

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

0.00
134.30

30
Count

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

SNIP

134.12

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Item ID: D4543-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Retainer, Outer, LH

Stop

NS2

Start Date: 4/24/13

Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/08/13

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/5/6

NKF

13-4-30

Picklist Print

April-24-13 9:48:36 AM

Page 1

Work Order ID: 100598

Parent Item: D4543-3

Parent Item Name: Retainer, Outer, LH

100598

D4543-3

Start Date: 4/24/13

Required Date: 5/08/13

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg reva DD verf:EC IPP REV:C 13.04.23 as
per dwg revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032

Purchased

No

100

sf

1,183.770

1.144

~~36.12632~~

M6061T6S 032

**

32.0

Jm 13-4-24

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

1183.77

121099

171.94

122256

46.78

122737

44.8

123097

71.9

123135

37.7

123137

51.85

123293

58.5

123483

260.6

123701

47.85

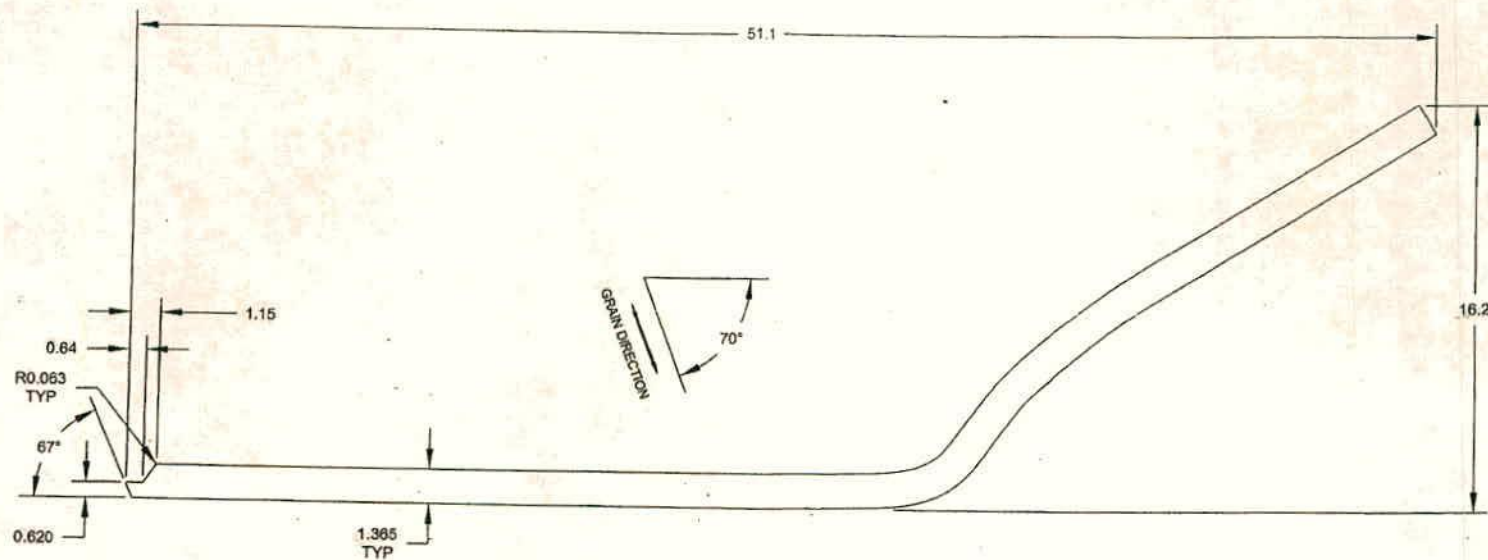
124629

199.85

125341

192

125341



D4543-3F FLAT PATTERN



RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVB.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
DATE	13.04.15	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	